

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-021061**Date Inspected:** 26-Dec-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Corporation, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Mr.Mia Quin Li**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Steel Barriers**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Delbert Humphrey was present during the times noted above for observations relative to the work being performed at ZPMC.

OBG, Bay 1

WELDING

This QA Inspector observed the following work in progress:

Traveler Rail 20TR2-043, slotted holes were being drilled in web of traveler.

OBG, Bay 13

WELDING

This QA Inspector observed the following work in progress: Steel Barrier E2-SB10-048 and W5-SB2-012, bolt holes were being threaded.

OBG Bay # 16

WELDING

This QA Inspector observed the following work in progress:

SMAW welding of weld joint identified W5-SB21-001-104, located on Steel barrier joint W5-SB21-001, welder is identified as 201074, ZPMC Quality Control (QC) is identified as Mr.Mia Quin Li. The welding variables recorded by QC appeared to comply with WPS-B-P-2113.

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OBG Bay #28

WELDING

This QA Inspector observed the following work in progress:

FCAW welding of weld joint identified SA3084C-004-005, located on Splice Plate, SA3084C-004, welder is identified as 059378, ZPMC Quality Control (QC) is identified as Mr. Liu dao feng. The welding variables recorded by QC appeared to comply with WPS-B-T-2232-ESAB.

OBG Bay # 28

NDT

The following NDT performed ZPMC NDT notification 07938:

This QA inspector performed MT testing on 15% of an area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector Delbert Humphrey generated an MT report for this date. Time of inspection was 9:30 hours. The members are identified as follows OBG, Steel Barriers and Splice Plates. The weld designations reviewed are as follow:

Steel Barriers:

E5-SB20-001-126, 128, 130, 116, 119, 121, 013, 125, 021, 027, 017, 048, 058, 055, 001, 003, 005, 007, 011.

E5-SB21- 001-126, 128, 130, 116, 119, 121, 013, 125, 021, 027, 017, 048, 058, 055, 063, 065, 067, 069, 071

E5-SB13-001-126, 128, 130, 116, 119, 121, 013, 125, 021, 027, 017, 048, 058, 055, 001, 003, 005, 007, 011.

Splice Plates:

SA3054A-001~007-001, 002, SA3116B-001~011-004, 005.

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.

Summary of Conversations:

No relevant conversations were reported on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Humphrey, Delbert	Quality Assurance Inspector
Reviewed By:	Hall, Steven	QA Reviewer
